

5/21

give back to  
Receiving when  
done step 9-13

Split w/o

DART AEROSPACE LTD	
Description: Door Assembly	
Dwg: D3296 Rev. A	

Work Order:	23199 A
Part Number:	D3296-041
Qty:	10 <del>30</del> 10

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	AB	05/05/09	10
2	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1	Batch: M16807	JL	05/05/18 30
3	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-3	Batch: M16807 M16645	JL	05/05/18 30
4	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-1	JL	05/05/18	30
5	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30
6	QC8	Second check	SD	05/05/18	30
7	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-3	JL	05/05/18	30
8	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30
9	QC8	Second check	SD	05/05/18	30
10	GA	Deburr D3296-1/3	SD	05/05/25	30
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05/06/2	30
12	QC3	Inspect Chemical Conversion Coat	SB	05/06/14	30
13	GA	Assemble hinges as per Dwg D3296 Pick: Qty Part Number Description Batch	SB	05/06/16	10
		1 D3161-7 Hinge B 22980 B 23567			
		1 D3161-9 Hinge B 23203			
		25 MS20470AD4-4 Rivet B 15815			
14	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05 06 22	10
15	QC3	Inspect Powder Coat	ML	05 06 22	10

RELEASED  
5/05/18

Dart Aerospace

DART AEROSPACE LTD	Work Order:	28199
Description: Door Assembly	Part Number:	D3296-041
Dwg: D3296 Rev. A	Qty:	10

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Step	Location	Procedure	By	Date	Qty
16	GA	Fabricate & assemble as per Dwg D3296. Pick: Qty Part Number Description Batch 1 D2137 Decal B21425 1 D2419 Handle B21426 1 D2462-0040 Seal B 19351 B22749 1 D2462-0053 Seal B22749 1 D2462-0245 Seal B22749 1 D2728-1 Decal B17991 1 D3296-1 Door Panel B23199 1 D3296-3 Door Panel B23199 1 AN960JD6 Washer M4970 1 MS20470AD4-6 Rivet 815924	SD	05/06/23	10
17	QC5	Inspect work to Step 20	Z	05.06.23	10
18	ST	Identify and Stock	DR	05/06/24	10
19	AC	Cost / part: 34.92	AL	05/06/27	10
20	DC	Close W/O 58.16 Inspect Level 21	TH	05.06.28	10

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	
B	04.11.26	Revised Steps 13-17	KJ/JLM	JL

RELEASED  
04/11/29

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 23199		WORK ORDER NON-CONFORMANCE								
DATE	STEP	Description of NC Section A		Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05.06.23	16	D2137 decal applied to wrong side.		Initial	Leave decal on and apply another decal as padding.	SB 05/06/23	2 05-06-23	BB	BB 05.06.23	BB 05.06.23

PAR#: N/AFault Category: N/ADQA: GPDate: 05/06/30

RETURN TO  
ENGINEERING

UNCONTROLLED  
SUBJECT TO A  
WITHHOLDING

WORK ORD

D3161-7 HINGE  
NO. 23788

.063

D3296-1 DOOR  
PANEL (1)

D3161-9  
HINGE

0.125

D2419 HANDLE (1)  
MS20470AD4-6 RIVET (1)  
AN960JD6 WASHER (1)

D3296-3 DOOR PANEL (1)

0.240 13.563 (13 EQUAL SPACES) 1.95

Ø0.141 (TYP, 3 PLACES SHOWN)

MS20470AD4-4 RIVET  
(25 PLACES)

Ø0.128  
(TYP 11  
PLACES)

RELEASED  
04.07.02

D2728-1  
DECAL

1.95

0.75

DART

0.75

D2462-0040 SEAL (1)  
D2462-0053 SEAL (1)  
D2462-0245 SEAL (1)  
(TRIM TO FIT)

NO STEP

D2137 DECAL

#### D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

✓✓✓✓

1 COPY IS  
MAILED

DESIGN	DRAWN BY	DART AEROSPACE LTD
if	if	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3296
DATE	DATE	REV. A
04.06.28	04.06.28	1 OF 2
TITLE	DOOR ASSEMBLY	SCALE
A	04.06.28	1:3
	NEW ISSUE	